

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022001**Date Inspected:** 17-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. An Qing Xian.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Chang xing Island in Shanghai, China. QA observed and/or found the following:

BAY # 14

This QA Inspector performed randomly Visual Inspection and Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6027 (UT) report for this date. The member is identified as OBG Segment 14East. The weld designations reviewed are as follows.

SEG3019Z-013

SEG3019X-099, 100

SEG3019U-004, 005

NDT Notification No-08560

This QA Inspector observed the following work in progress:

OBG 14EAST

SMAW process Repair welding:

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This QA Inspector observed ZPMC qualified welding personnel identified as 067656 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment 13BE + 13CE Deck panel to Deck panel. Joint identified as OBE13A-009. ZPMC QC Identified as Zhan Hai Feng with temporary welding repair report WRR-B-WR20075. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair.

This QA Inspector observed ZPMC qualified welding personnel identified as 066326 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment. Joint identified as DP3092-001-092, 093. ZPMC QC Identified as Zhan Hai Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2114 -FCM-1.

SMAW process Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 051359 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment Side plate to floor beam. Joint identified as SEG3011G-206. ZPMC QC Identified as Zhan Hai Feng with temporary welding repair report WRR-B-WR17660. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair.

SMAW process Repair welding:

This QA Inspector observed ZPMC qualified welding personnel identified as 051359 Perform Shielded Metal Arc Welding (SMAW) on OBG Segment Side plate to floor beam. Joint identified as SEG3011G-212. ZPMC QC Identified as Zhan Hai Feng with temporary welding repair report WRR-B-WR17656. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair.

FCAW process:

This QA Inspector observed ZPMC qualified welding personnel identified as 066263 Perform Flux Core Arc Welding (FCAW) on OBG Segment I rib. Joint identified as VP3007-001-059, 060, 072, 073. ZPMC QC Identified as Zhan Hai Feng. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2211-ESAB.

OBG 14 West

SMAW Process:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint SEG3020U-587 located on Anchor Plate to Longitudinal Diaphragm at panel point 126 of OBG Segment 14W. ZPMC Welder is identified as 067588. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-3G-(3F)-FCM-Repair, which is used as per Critical Welding Repair (CWR) B-CWR1-2854.

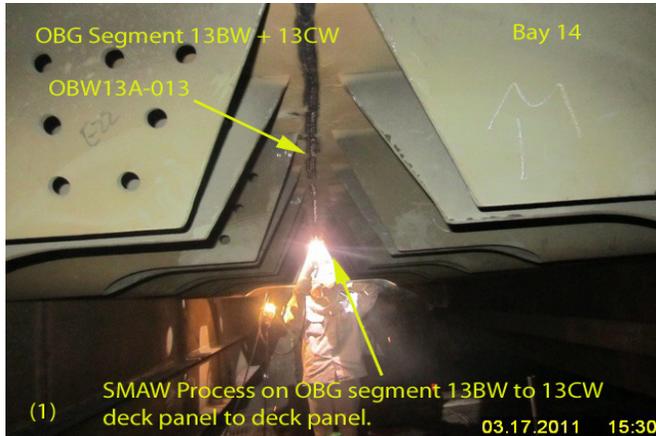
SMAW welding of weld joint SEG3015G-001 located on Deck Panel Diaphragm to Deck panel Diaphragm at panel point 123.5 of OBG Segment 13CW. ZPMC Welder is identified as 067701. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2213-Tc-U4b-FCM-1.

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SMAW welding of weld joint OBW13A-013 located on Deck Panel to Deck Panel of OBG Segment 13CW to OBG Segment 13BW. ZPMC Welder is identified as 064461. ZPMC Quality Control (QC) is identified as Mr. Wang Xing Pin. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1. For more information see below attached picture number 1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho: 150002048250, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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